S.V. 243, 244, 246, 247 & 262 C.C. D.V.

CG 03 CODE KY-795-D PKG. PUNCHED & CHECKED

EST. WGT. 1178 LBS.

MAY 1 - 1980 OK

STD. HRS. 11.1 TIME 7A M

PROCESSES		APPROVED BY
( ) KY-795-D	(1)	EWK 10/5/76
( ) ALTERNATE	( )	DCG 10/7/76
( )	( )	MTW 10/11/76
( )	( )	
TYPED BY NE 3/3/77		

14 YC-2-B 93 4 Lot 24775 , 2000
14 YC-2-B 93 4 Lot 24773 , 1700
14 YC-2-B 93 4 Lot ,

Homog # 3 - 1st Pass

APR 29 1980

Total Wgt. 4878#

NON-BLEEDING

EQUIPMENT		NAME: 60" (7906) "KROLOR" YELLOW - MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & ~~205~~ 1	1	Run ~~26" (418 G)~~ water in V-203 RUN AGITATOR ON HIGH SPEED.			
	2	Weigh in drum & pour in	500	32-D	500
	3	Dump in & stir 5 min Lot	74x50	YC-2-B	3700
		Record: Start 2:30 Am 24775	40x50		2000
		Fin 5:15 Am 24773	34x50		1700
263		75" (1275 G)			
	4	Adj to ~~78" (1328 G)~~ 2400-2600			
	5	Pump V-203 thru Homog # 3 at ~~1800-2200~~ psi into V-~~205~~ 263			
	6	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water 263			
	7	Record: V-~~205~~ Vol " & adj to 51" (1874 G)			
	8	Inspect homog. strainer & clean if necessary			
SV & ~~205~~ 263 2	9	Run 5 "(514 G) water into V-262, install temp charts & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 11:55 Am Total Min			
		Note: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205			
	11	When V-205 MTY run in 5" (240 G) water & pump thru Homog at 4800-5200 psi			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120°F			
	14	Weigh into V-384 & pump to V-349	2830	32-D	2830
	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 29" (1372 G) & stir 15 min or longer			
	17	Record: Be' 1.071 ~~(9.85 ± 0.2)~~ (1.070 - 1.073) g/ml			
SV 4	18	When S 11 Homog complete, adj. to 25 " (3495 G)			
	19	Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	10	7-D	5
		Siphon into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min & Record: HT 192°F & Rec 192°F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 69" (1898 G) water into V-343			
	22	Meter in from V-386 M 30 8502 #/Gal 4358 Gal		27-D	416
	23	Stir 15 min or longer			
	24	Record: Be' 1.015 ~~(2.3 ± 0.1)~~ (1.014 - 1.015) g/ml			
SV 6	25	When S 20 heating complete Record: pH 10.0 (9.5-10.0)			
	26	Set V-343 acid pump at 96 setting (±225 min)			
	27	Set V-349 Silicate pump at 82 setting (± 180 min)			
	28	Immediately meter in V-343 & V-349 Maintain SV at 190-194°F during strike			

F/N

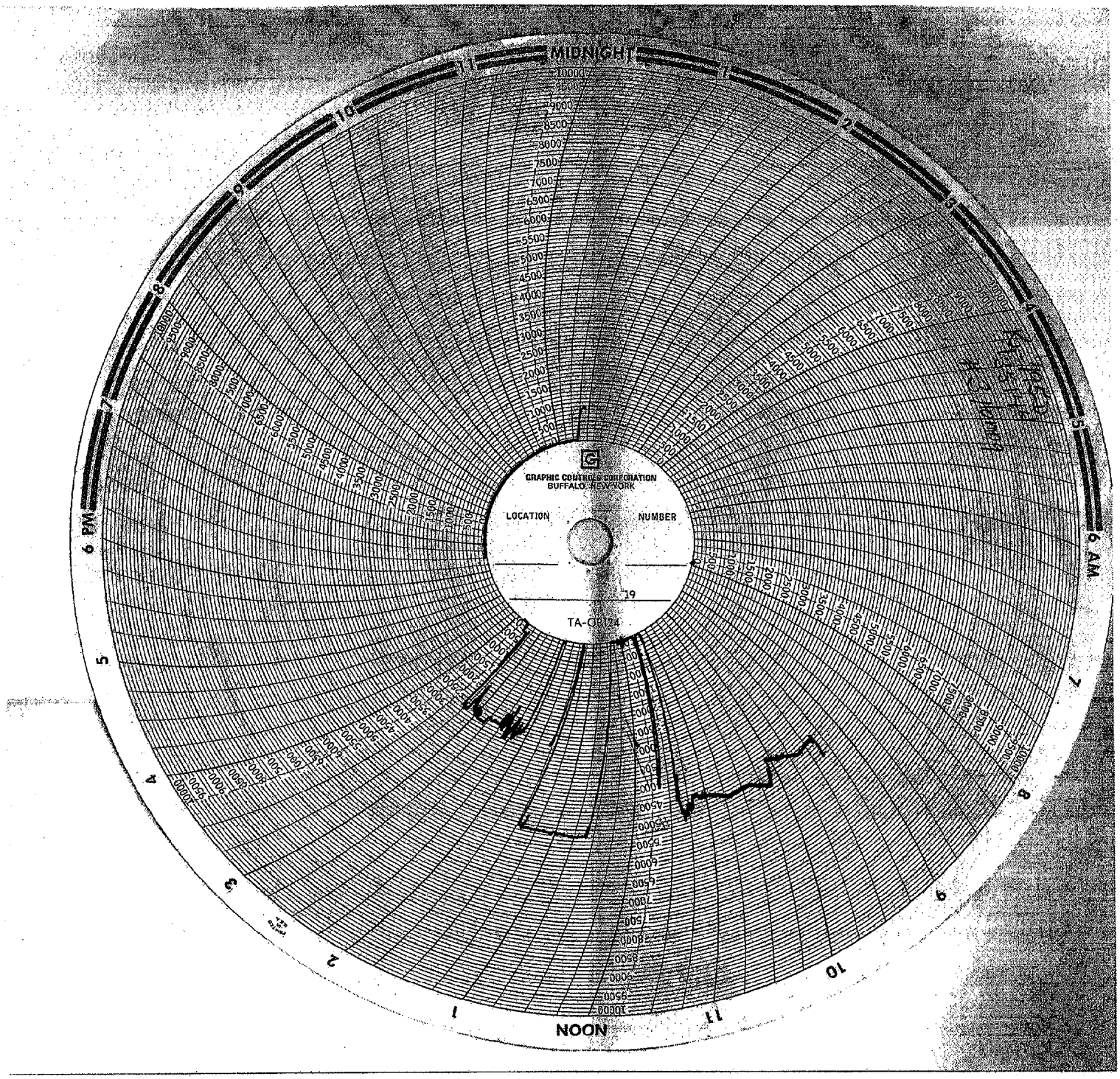
K 13829 REV.

V-262

EQUIPMENT		PAGE 2 CC 03 CODE KV-795-D(1)-ALT EST. WGT. 4878 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6 Cont.	29	Record: V-343 Start 5:30 PM V-349 Finish 10:15 PM Minutes 285 225		Note 11	
		Record: Time V-343 in V-349 in SV pH Normal pH		CONT RUN M-32 AT REQUIRED RATE 32	
		at 20 min 5:50 PM (64) (26) 10.0 9.0-10.0		RUN M-32 AT 22	
		40 min 6:10 (58) (23) 10.0 9.0-10.0		REDUCED N-27-D RATE ACCORDINGLY	
		1 hr 6:30 (51) (19) 10.0 9.0-10.0			
		2 hrs 7:30 (33) (10) 10.0 9.0-10.0			
		3 hrs 8:30 (14) (0) 10.0 9.0-10.0			
		Finish 9:15 (0) 22 7.5-8.5		M-32 LINE TO V-262	
		Note: If pH drops below 9.0 in 1st 2 hr, stop pumps & see Supv.		MUST BE RESTRICTED	
		If pH above 8.5 at final adj to 7.5-8.5 Record: pH Assume 77%		27-D	
357 7	30	Run 16" (108 G) water into V-357 & heat to 135-140°F	220	15-A	220
	31	Dump in & stir to dissolve for S 38			
Drum 8	32	Weigh into 55 Gal Drum Assume 50%	60	7-D	30
	33	Fill with water & stir 2 min for S 40			
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
	35	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	36	Turn off steam			
	37	Sift in 3 bags	150	128-A	150
	38	Run in V-357 from S 31 & stir 5 min			
	39	Record: pH 3.7 (3.3-3.7) & if necessary adj (down only)		15-A	
		to 3.3-3.7 & Record: pH			
		Note: Dissolve extra N-15-A in water at 135-140°F in drum. Use ± 40 Gal water to 50# N-15-A. Stir SV 5 min after each addition.			
	40	Siphon in N-7-D from S 33 in 4-6 min & stir 5 min			
	41	Record: pH 4.2 (4.0-4.2) & if necessary adj to pH 4.0-4.2 & Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	42	Pour in & Stir 15 min	45	978-A	45
	43	Stop agitator			
		Start 7:00 AM 2:00 PM 3:00 PM Finish 3:00 PM 11:00 PM 5:00 PM Optr 54-201 335 282-201 259-201			
		Step V-262 (20 RPM) V-243, 244, 247			
		9 (5") 10"			
		18 (35") 68"			

K13330 REV.

DUP050461278



N32447.01

DUP050461279